

**What is Claimed is:**

1. A method of forming localized positive optical power units in a substrate, comprising:  
forming a master in the form of a complement to a desired arrangement of  
5 localized positive optical power units on a substrate; and  
molding a plurality of localized positive optical power units onto a substrate using the master.
2. The method of claim 1, wherein the master is designed using one of  
10 computer aided design or an optical ray tracing program.
3. The method of claim 2, wherein the master is manufactured using precision milling or is ground to form a press or planar mold.
- 15 4. The method of claim 1, wherein the master is formed of a thermal plastic material which is hardened to retain its shape.
- 20 5. The method of claim 4, wherein the master is formed of photo-polymer that is polymerized with ultraviolet light.
6. The method of claim 1, wherein the master comprises a substrate having a first layer comprising aluminum deposited thereon and a second layer comprising nickel deposited on the first layer.
- 25 7. The method of claim 1, wherein the master is configured to wrap around a cylinder or roller, which is then used to mold a plurality of bead-like projecting members onto a substrate.
- 30 8. The method of claim 1, wherein the step of molding a plurality of localized positive optical power units onto a substrate using the master comprises heating the master and then embossing a plurality of localized positive optical power units onto a substrate using the heated master.

9. The method of claim 1, wherein the step of forming a master in the form of a complement to a desired arrangement of localized positive optical power units on a substrate comprises providing a base substrate; and projecting microdroplets of a hot liquid ink onto the base substrate, thereby forming a  
5 complement of a desired arrangement of localized positive optical power units on the base substrate.

10. The method of claim 9, wherein the localized positive optical power units comprise projecting members.  
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11. The method of claim 10, wherein the projecting members are spherical, or approximately spherical.

12. The method of Claim 9, wherein the substrate is metal, or plastic.